

SPLIT

Date: Monday, 7/16/2007 2:48:02 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG ASSEMBLY
Job Number : 33566	
Estimate Number : 10012	
P.O. Number : <i>N/A</i>	Part Number : D27363
This Issue : 7/16/2007	Drawing Number : D2736 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : A
Previous Run : 33082	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 8/5/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 40 Um: Each
Comment : Est Rev:D Removed from 9 digit 05-10-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2591	Lug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2591	Lug	<i>B24829</i>

Lug Bracket

FC 07/11/08 (40)

2.0	D27353
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2735-3	Lug Bracket	<i>B34920 x 24</i>

B33569 x 16

FC 07/11/08 (40)

3.0	LARGE FAB 1
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LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2591 & D2735-1 as per QSI 004 and Dwg D2736 using locating Jig DT8484

Steel Rod Batch: *m4326*

FC 07/11/08 (40)

4.0	QC9
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VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-11-08 (40)

5.0	QC5
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INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

cont'd
5/21/09 (+40)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 33566

Part Number: D27363

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

W for Gary 07.11.09

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07.11.09 (6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07.11.09 (6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.09 (6)

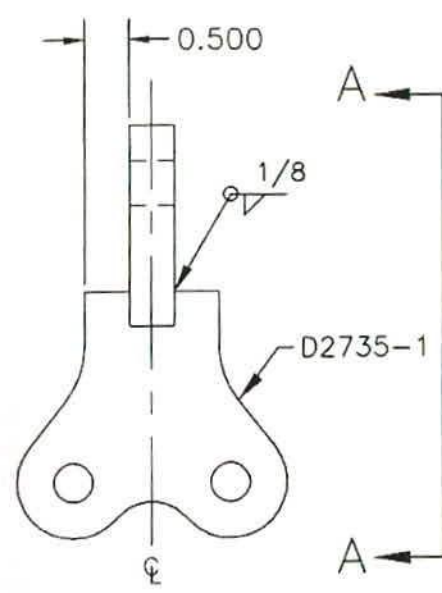
Job Completion



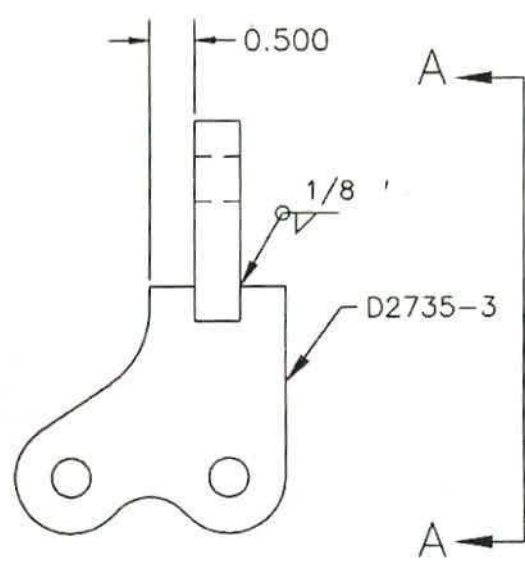
W 07.11.09



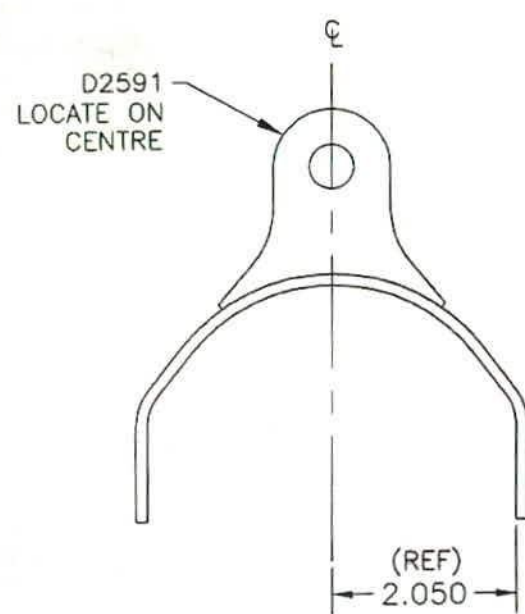
DESIGN <i>max</i>	DRAWN BY <i>max</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>GA</i>	DRAWING NO. D2736	REV. A SHEET 1 OF 1
DATE 97.12.18		TITLE LUG ASSEMBLY	SCALE NTS
A	97.12.18	NEW ISSUE	



D2736-1 LUG ASSEMBLY



D2736-3 LUG ASSEMBLY



VIEW A-A

NOTES:

- WELD PER DART QSI 004
- FINISH: POWDER COAT WHITE PER DART QSI 005 4.3
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- PART IS SYMMETRIC ABOUT CENTRE-LINES (C)

SHOP COPY
RETURN TO:
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
33566
97/12/24 DS
ECN 057